



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW109-3501-08-115

Job Sheet 199195



4 PAT L

Part No: RBW109-3501-08-115

Job Qty: 2 pcs

Part Name: Adapter, Landing Gear Shockstruts Nitrogen Change



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/14/19

Job Tracking No:

Due Date: 9/13/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG RBW109-3501-08-115 Rev 3 IPP Rev A 18.02.14 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	2 pcs	9/13/19	9/13/19	0.00	0.00	Purchasing - 1		AC SEP 10 2019
		4 pcs					Purchasing - 2		
							Purchasing - 3		
110	Packaging 2-1 - Receive - B4B	2 pcs	9/13/19	9/13/19	0.00	0.00	Packaging 2 - 1 - B4B		AC SEP 10 2019
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		
							Packaging 2 - 28 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S212480



Part: RBW109-3501-08-115

Job No: 199195

Serial No/Batch: S212480

Revision: 3

Inspector:

Exp Date:

Instructions:

Date: 08/10/19

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				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
120 QC 6	2 pcs	9/13/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	DAS
				QC 6 - 40	81
				QC 6 - 81	9-89
					SEP 13 2019
130 Packaging 3-1 - Stock - B4B	2 pcs	9/13/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - FG	2 pcs	9/13/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - SA - 53	
					SEP 16 2019 DAS
					70
					9-89

Part Op 100 - (Purchasing) Issue P/O: 180424 MANUFACTURE RBW109-3501-08-115 AS PER DWG Supplier: METEC
 Descriptions: ***NOTE*** Ensure solder joint is clean of all debris. Soldered joint must hold 1500psi of nitrogen charge. Certificate of conformity is required
 110 - (Receive & Inspect for Damage & Mat'l Certs)
 120 - (QC6- All purchased or subcontracted products)
 130 - (Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release)

x4 Rhin aug 14 2019

GA106

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
RBW109-3501-08-115P	Adapter, Landing Gear Shockstruts Nitrogen Change	2 Ea (1 ea)	100-Purchasing	5212478
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW109-3501-08-115P	2	0	0
Part Specifications				
Specifications could not be found.				

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

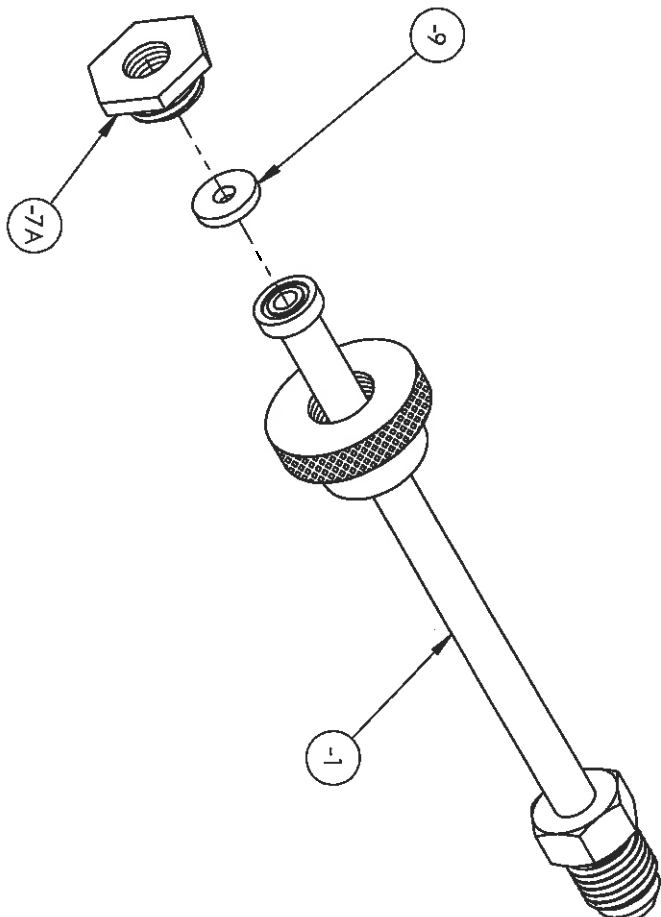
Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		MRB (QS1042)																													
Date: _____		Sequence #: _____		QTY Affected: _____		Disposition																													
Description Work Order Deviation				Completed By																															
_____				Lead hand / Supervisor																															
_____				QC / QA Coordinator																															
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table> Other/Details: _____						Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		MERGED -7, -8 & -9 INTO -7 AS BUYOUT. DELETED PAGE 4. -5 CHD TUBE DIMENSIONS, WAS $\phi .190 / \phi .250$, IS $\phi .210 / \phi .280$.	9/14/2010	WP	DW
2		-5 CHD MATERIAL FROM BRASS TO 303/304, ADDED EXTRA GASKET RELIEF. MERGED -7, -9, AND -11 INTO -7 ASSEMBLY.	9/20/2010	WP	DW
A2		CORRECTED P/N WAS RBW109-351-08-115 IS RBW109-3501-08-115. -5 CHD ID FROM $\phi .115$ TO $\phi .156$.	6/26/2012	JAG	SE
2A		UPDATED SHEET FORMATS AND DRAFTING STANDARDS. SEPARATED -3 & -5 TO INDIVIDUAL SHTS. ADDED -7A TO BOM.	10/16/2013	CFS	RW
3	16-0208	-3 CHD DIM WAS $\phi .24 \pm .001$ $\pm .25$ IS $\phi .242 \pm .001$ $\pm .25$. -5 CHD DIMS WAS $\phi .156$ IS $\phi .135 \pm .030$ WAS $\phi .240$ (S.F. -3) IS $\phi .240 + .000 / -.002$ (S.F. -3). WAS $\phi .375$ IS $\phi .38$. DELETED NOTE 1 SHEET 1.	11/22/2016	RJC	JAG



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS		Pg.
	X		-1	1	SOLDER ASSY.				2
	1		-3		FLARED FITTING, 37°	316 S.S.	7/16-20 FOR 1/4 OD TUBE (MCMASTER-CARR #S0715K522) MODIFIED		3
	1		-5		TUBE	304 S.S.			4
	1		-7		FITTING, THUMB NUT		(AIRCRAFT SPRUCE #06-11700 SCHRAEDER #6116) MODIFIED		2
			-7A	1	FITTING, HEX NUT		PART OF -7		1
	B/O		-9	1	GASKET	HARD FIBER	(AIRCRAFT SPRUCE #SK2043-5)		1
	-1								

DART
AEROSPAC

TITLE
ADAPTER, L/G SHOCKSTRUTS
NITROGEN CHARGE

DWG NO.
RBW109-3501-08-115

REV
3

MAT'L
BREAT
FINISH
SPEC

DRAWN BY: PERRITT
CHECKED: DUERFELDT
OPPS APPR: ANDERSON
QA APPR: LINDSAY
APPROVED: GILBERT

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .005 FRACTIONS ± 1/8
.X ± .01 ANGLES ± 5°
1. BREAK ALL SHARP EDGES
2. DIMENSIONAL LIMITS APPLY
3. AFTER PLATING AND TOL PER
ASME Y14.5M-2009
USED ON MODEL

SCALE 1:1 DATE 4/23/2010 SHEET 1 OF 4



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB044266



Supplier: WEJ001-VC
Wejay Machine Products Co. Ltd
600 O'Connor Drive
Kingston
ON
K7P 1N3 Canada
Phone: 613-384-1662
Fax: 613-384-2997

PO No: POHB044266
PO Date: 8/14/19
Due Date: 9/11/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	199195	RBW109-3501-08-115P ✓			Adapter, Landing Gear Shockstruts Nitrogen Change As Per Dwg RBW109-3501-08-115 Rev. 3	Firmed	-	9/11/19	4 Ea	0 Ea	4 Ea	\$498.00/Ea	\$1,992.00

4X SEP 10 2019 AC

Grand Total: \$1,992.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

Plex 8/14/19 12:43 PM dart.lussier.patrick

Packing Slip 39637



WEJAY MACHINE PRODUCTS COMPANY LIMITED

800 O'CONNOR DRIVE

KINGSTON, ON, CANADA K7P 1N8

TEL: 813-884-1882 FAX: 813-884-2987

WEJAY.COM

SOLD TO
Dart Aerospace
1270 Aberdeen Street
Hawkesbury ON K6A 1K7

SHIP TO
Dart Aerospace
1270 Aberdeen Street
Hawkesbury ON K6A 1K7

INVOICE DATE		YOUR ORDER NO. POHBO44266 ✓		DATE ORDERED 08/14/19		SHIPPED VIA Best way	
CUSTOMER CODE DART		PROV. LIC. NO.		Extra ☐ Exempt ☐		TERMS	
QUANTITY ORDERED 4	R.O. 0	QUANTITY SHIPPED 4 ✓	DESCRIPTION Adapter, landing gear shockstruts, Nitrogen charge As per drawing RBW109-3501-08-115 Rev. 3 ✓ Dart part number: RBW109-3501-08-115P ✓ Job Number: 199195 ✓ Required by: September 11, 2019			UNIT PRICE	AMOUNT
			<i>F 7761 8853 1590</i> RECEIVED SEP 10 2019 DART AEROSPACE LTD. RECEIVED SEP 08 2019 DART AEROSPACE LTD. H.S.T.				

ORDER: COMPLETE ☐
PARTIAL ☐

TOTAL

RECEIVED BY _____
1.5% PER MONTH (18% PER ANNUM)
CHARGED ON OVERDUE ACCOUNTS

NO GOODS RETURNED WITHOUT
PRIOR AUTHORIZATION



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2997

CERTIFICATE OF COMPLIANCE

CUSTOMER: DART AEROSPACE		DATE: SEPT. 6, 2019	
		P.O.# POHB044266 ✓	
		WEJAY JOB# 39637	
I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below. Any exceptions will be listed as NCR items.			
PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
RBW109-3501-08-115P	4 ✓	Machine/Modify/Assemble as per drawing	RBW109-3501-08-115
		Spec's	Rev.3
Materials used: Item -5: Ref. Wejay TN#34007-1 (3/8" OD x .12" wall 316 sst seamless tube) Item -3: Ref. Wejay TN#34428-1 (McMaster Carr #50715K522) Item -7 and -7A: Ref Wejay TN#34427-2 (Aircraft Spruce #06-11700 Schrader #6116) Item -9: Ref Wejay TN#34427-1 (Aircraft Spruce #SK2043-5)			

Records of Inspection/Test will be retained for 5 years minimum.

Yours truly,



Edward Jansen
Authorized Q.A. Signatory